

Work Order ID 57772

April 14, 2010 1:53:45 PM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 14/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-4-14 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3852	Rev A

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAF

10-04-20

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 111679

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

②

JPL 10-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3852-041**Accept****Setup****Start****Revision ID:****Item Name:** Rib Assembly**Stop****Start Date:** 14/04/2010 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 20/04/2010 **Req'd Qty:** 2.00**Customer:****Reference:****Approvals:** **Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop****Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC9- Inspect visual per QSI004- Fusion Welds

**Set Up/
Run Hours**

0.00

**Draw
Number**

Rev.

**Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

2 10.04.21

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1041/21

0.00

2
-041

150



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAJ
10-021-022

Memo

0.00

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 14/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Memo

0.00

10/04/23 JJ

Quality Control

MM
10-4-22

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57772



Parent Item: D3852-041



Parent Item Name: Rib Assembly

Start Date: 14/04/2010

Required Date: 20/04/2010

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3 		Manufactured		No		100	Each	12.2238	0.3789			SAD 10-04-20

Basket Hoop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

12.22380526

55697

0.22380526

56426

6

57504

6

0.3789

D3759-1



Bushing

Manufactured No 100 Each 57.0000 2.0000



GL 10-04-20

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

57

54072

9

57184

12

57595

36

2

X

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

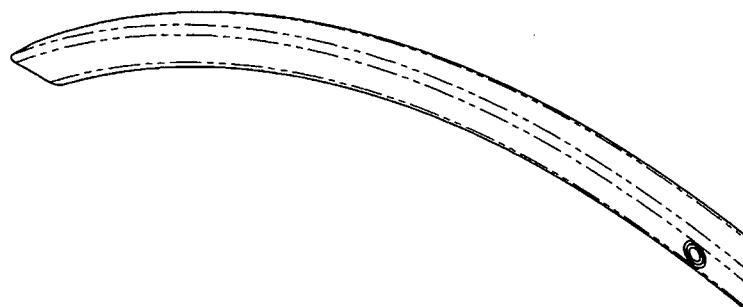
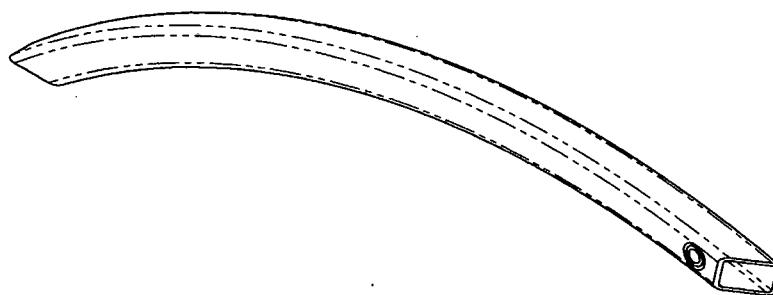
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2

1

**D3852-041 RIB ASSEMBLY****D3852-042 RIB ASSEMBLY**

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.83 lbs EACH
 8) WELDING: PER QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1	1	D3852-1	RIB
5		1	D3852-2	RIB

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 57772*Bl0-4-14**RELEASED 08/11/08 MP*

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1a</i>		
DRAWN	<i>1a</i>		
CHECKED	<i>1a</i>		
MFG. APPR.	<i>M</i>		
APPROVED	<i>M</i>		
DE APPR.	<i>M</i>		
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3

TITLE **RIB ASSEMBLY** SCALE **NTS**

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B

D

C

B

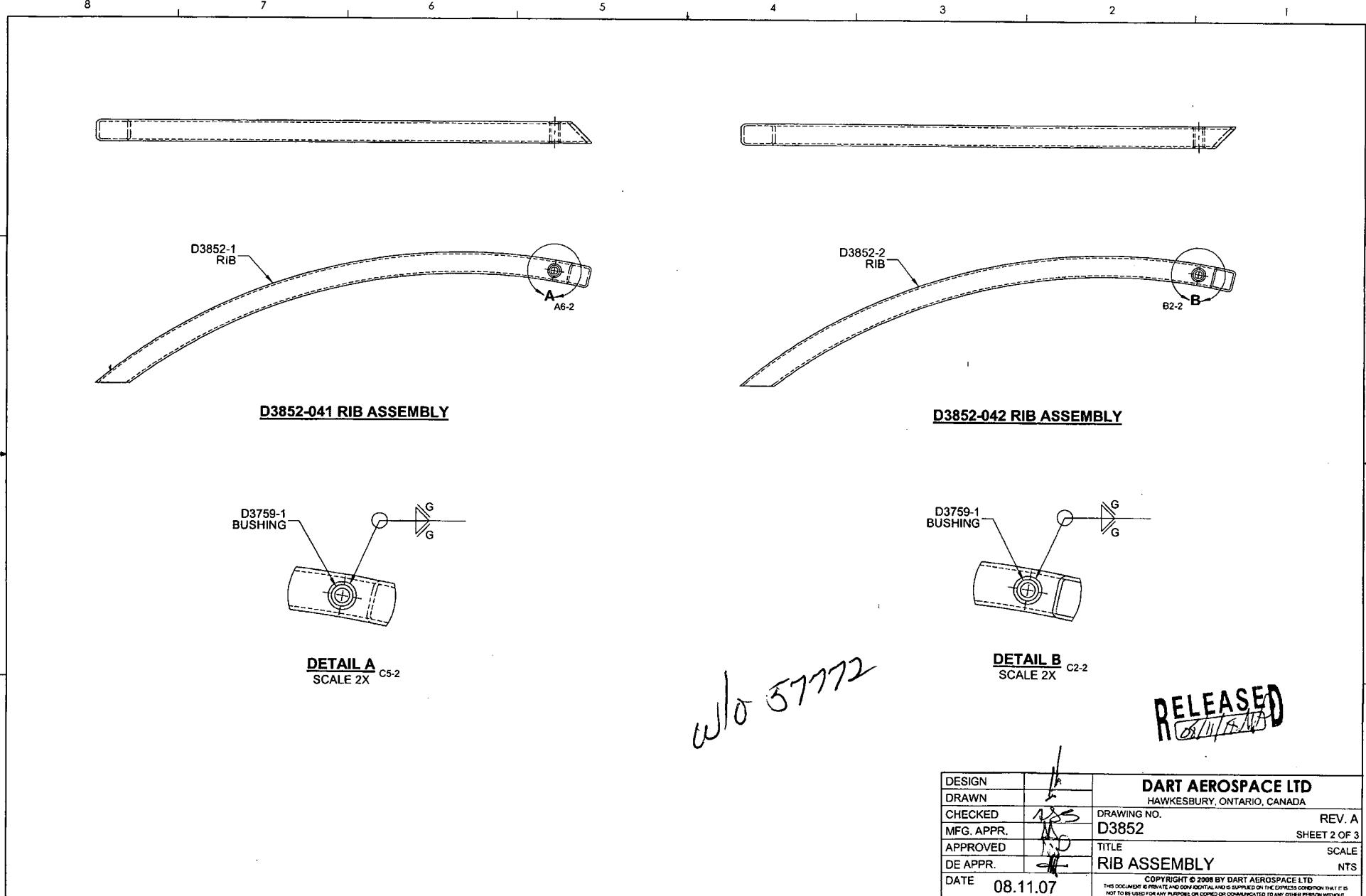
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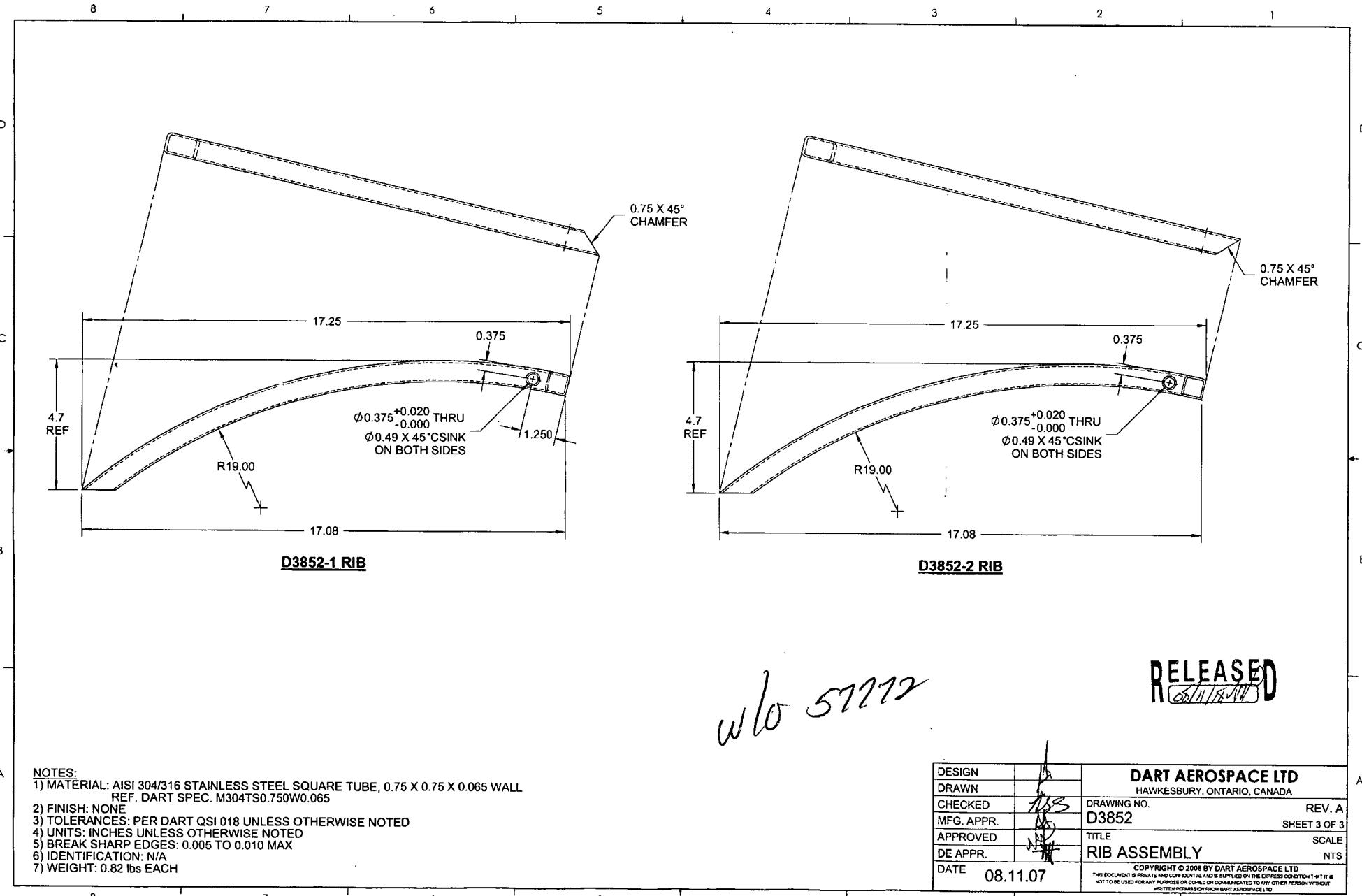


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